

Work Order ID 129666

February-23-15 10:14:56 AM

129666

Page 1

Item ID: D4113-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly, Baggage Door
 Start Date: 2/23/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1502-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4113	A

100 0.00

100

Waterjet Memo 0.00 (1) DL15/03/07

FLOW CNC Waterjet

304.063

1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00 (1) DL15/03/07

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Item ID: D4113-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly, Baggage Door
 Start Date: 2/23/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>51092</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MF 15-3-10

MLD 15-03-11

HS-3-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

February-23-15 10:14:55 AM

Page 1

Work Order ID: 129666

129666

Parent Item: D4113-041

D4113-041

Parent Item Name: Doubler Assembly, Baggage Door

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3622-1 *D3622-1* Ball Stud		Manufactured	No			130	Each	28.0000	1	1		15/03/10	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST052		28							
				124028		18							
				128951		10							
M304S16GA *M304S16GA* 304/316 Sheet .063		Purchased	No			100	sf	536.5689	0.1434	1		02/15/03/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		536.5689							
				m131384		220.5689							
				m131503		316							
MS20426AD4-5 *MS20426AD4-5* RIVET		Purchased	No			130	Each	2,515.000	2	2		15/03/10	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2441							
				m125807		60							
				m130922		2381							
				ST312		74							
				m125807		74							

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:14:55 AM

Page 2

Work Order ID: 129666

Parent Item: D4113-041

Parent Item Name: Doubler Assembly, Baggage Door

129666

D4113-041

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

MS21069-5

Purchased

No

130

Each

31.0000

1

1

DAS
36
9-89

MS21069-5

Anchor nuts

**

15/03/10

Location

Loc Qty

Loc Code

ST301

31

m129611

31

130

Each

346.0000

2

2

DAS
36
9-89

NAS1149C0563R

Purchased

No

NAS1149C0563R

Washer

**

15/03/10

Location

Loc Qty

Loc Code

ST271

346

m125928

5

m131026

341

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

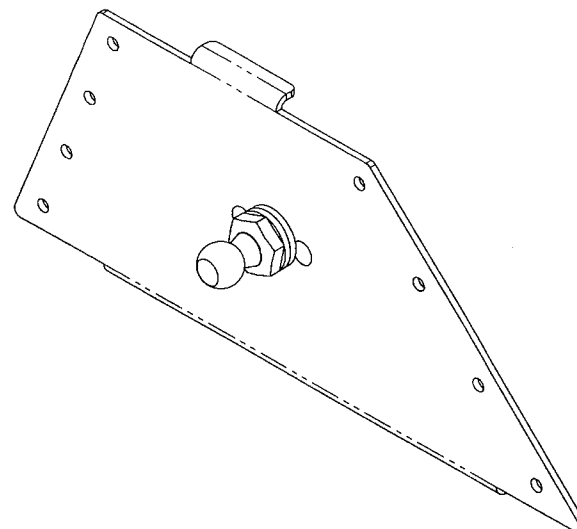
Work Order update only ☐

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Transport ☐									
Unapproved ☐									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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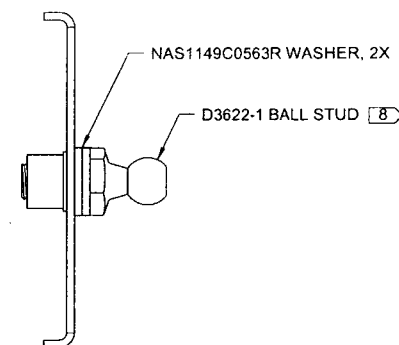
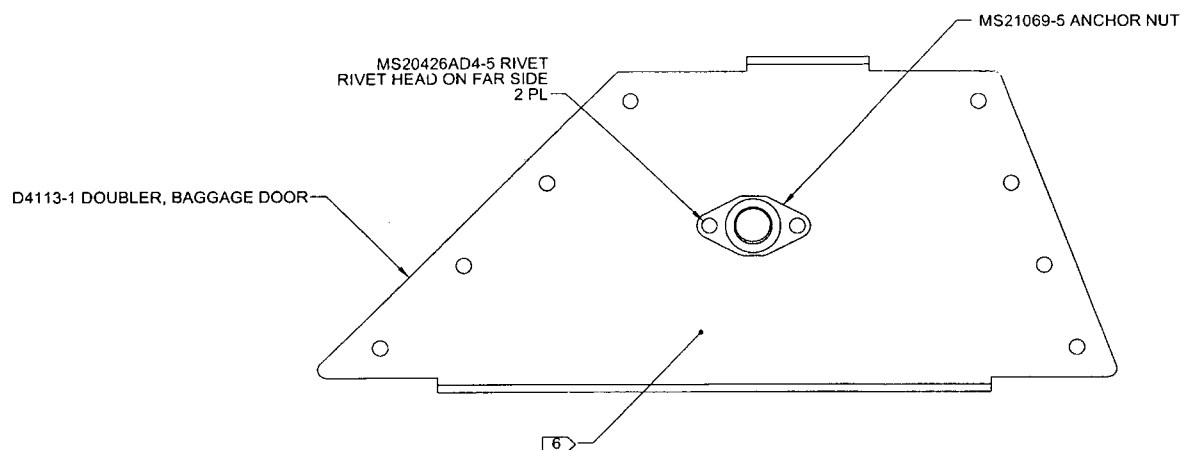
D4113-041 DOUBLER ASSY, BAGGAGE DOOR

UNCLASSIFIED
 SECURITY
 NO. 129.666.MLS
 1502-23

RELEASED
 2010-09-23
 JWP

A		NEW ISSUE		JPH		10.07.20			
REV.		DESCRIPTION				BY		DATE	
DESIGN		JPH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		JPH							
CHECKED				DRAWING NO.				REV. A	
MFG. APPR.				D4113				SHEET 1 OF 3	
APPROVED				TITLE				SCALE	
DE APPR.				DOUBLER ASSEMBLY				NTS	
DATE		10.07.20		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

Qty -041	Part Number	Description
	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
1	D4113-1	DOUBLER, BAGGAGE DOOR
1	D3622-1	BALL STUD
2	MS20426AD4-5	RIVET
2	NAS1149C0563R	WASHER
1	MS21069-5	ANCHOR NUT



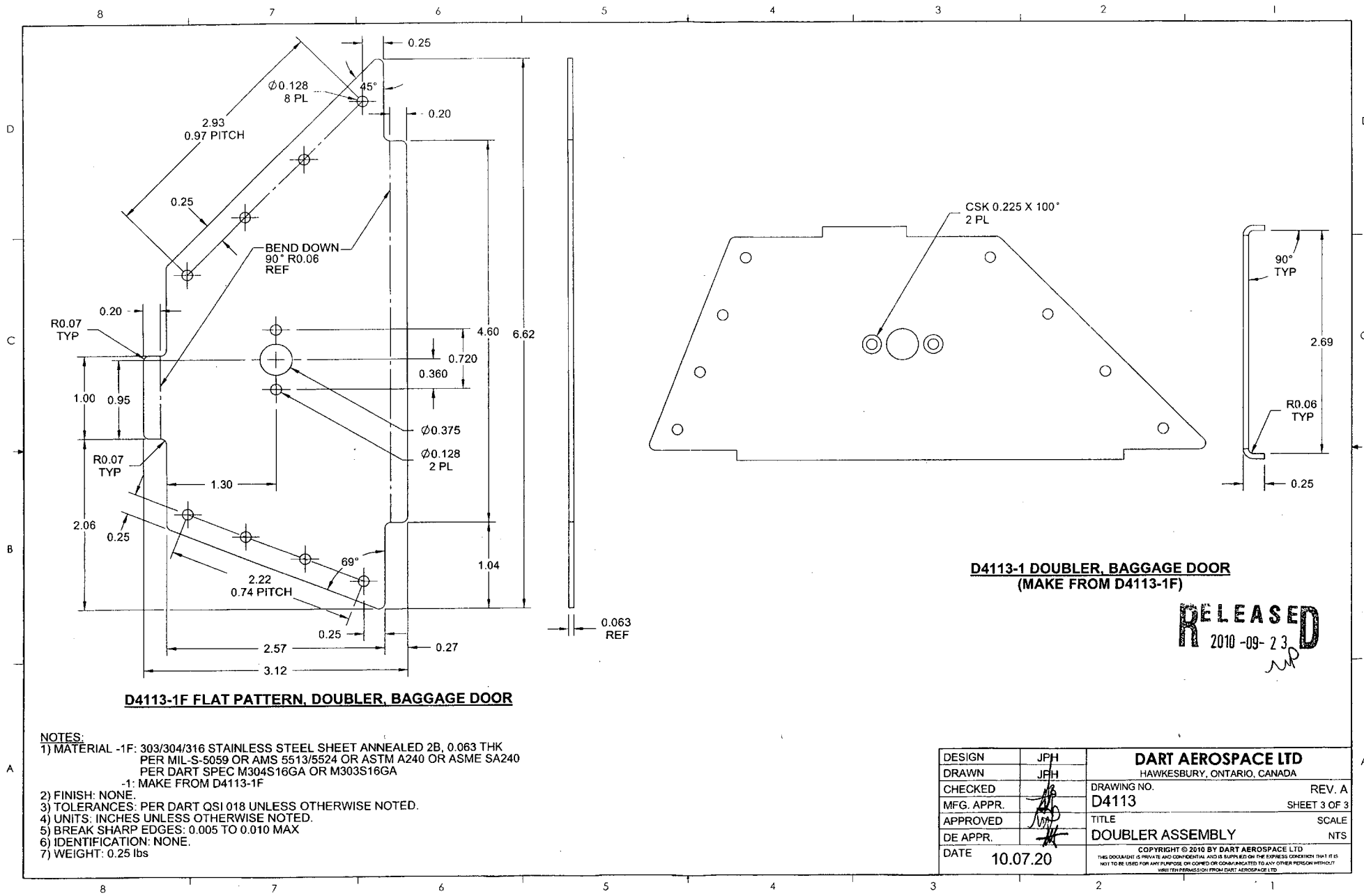
D4113-041 DOUBLER ASSY, BAGGAGE DOOR

RELEASED
R 2010-09-23 D
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENT P/N D4113-041 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) TORQUE TO 15 IN.LB

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4113	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE DOUBLER ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.20		



D4113-1F FLAT PATTERN, DOUBLER, BAGGAGE DOOR

**D4113-1 DOUBLER, BAGGAGE DOOR
(MAKE FROM D4113-1F)**

RELEASED
2010-09-23
MP

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1: MAKE FROM D4113-1F
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE.
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4113	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	